

Work Order ID 133725

Tuesday, June 16, 2015 10:54:49 AM

133725

Page 1

Item ID: PB67-43001-17 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Aft Adjustable Blade Support Assembly
 Start Date: 6/16/2015 Start Qty: 3.00 *3* Cust Item ID:
 Required Date: 6/16/2015 Req'd Qty: 3.00 *3* Customer:
 Reference:

Approvals: Process Plan: MCS Date: JUN 17 2015 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
B67-43001-17	Rev C								

100 Weld per dwg A/R Aluminum rod Batch: 128316 0.00 3 JUL 22 2015 DAS
 100 Large Fab 24
 Large Fab 9-89

- Memo 0.00
 1- make a 0.090" chamfer in the 1.00" hole before welding
 2- grind weld flush in area of PB67-43001-249 only
 3- install helicol insert as per dwg J.L.L. 15/07/22
 4- assemble parts and weld as per dwg

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00 3 15-07-27 DAS
 110 QC Memo 0.00 9
 Quality Control 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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133725

Page 2

Item ID: PB67-43001-17

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Adjustable Blade Support Assembly

Start Date: 6/16/2015 Start Qty: 3.00 ***3***

Cust Item ID:

Required Date: 6/16/2015 Req'd Qty: 3.00 ***3***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120									DAS
QC	Memo	0.00				③	1507-27		9 9-89
Quality Control									
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150									
HandFinish	Memo	0.00							
Hand Finishing									
160	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3	0.00							
160									
Powdercoat	Memo	0.00							
Powder Coating									
	1- MASK TUBE FROM BASE TO GUSSET START TIME: 8:24 AM								
	OVEN TEMPERATURE: 320°C FINISH TIME: 9:15 AM								

3x 4 15/07/9

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Adjustable Blade Support Assembly

Start Date: 6/16/2015 Start Qty: 3.00

3

Cust Item ID:

Required Date: 6/16/2015 Req'd Qty: 3.00

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200

Identify as per dwg & Stock Location: W/P

0.00

200

Packaging

Memo

0.00

Packaging

MF 15-8-14

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

MLSAUG 17 2015MF 15-8-14

DQA: _____ Date: _____



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OTHER :																																																																							

Picklist Print

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Page 1

Work Order ID: 133725

133725

Parent Item: PB67-43001-17

PB67-43001-17

Parent Item Name: Aft Adjustable Blade Support Assembly

Start Date: 6/16/2015

Required Date: 6/16/2015

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A 08-06-26 new issue DD verified by:ec
10.09.28 per rev C dwg EC verified by:DD

IPP Rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-71		Manufactured	No				Each	5.0000		3			

PR67-43001-71

20° Blade Support Assembly

Location Loc Qty Loc Code

Mezz2

5

113382

5

100

Each

5.0000

1

3

2 x 113382 MF
15-7-13

PB67-43001-249

Manufactured

No

PR67-43001-249

Inner Tube Bushing

Location Loc Qty Loc Code

WA003

5

133229

5

100

Each

7.0000

1

3

MF 15-7-13

PB67-43001-253

Manufactured

No

PR67-43001-253

Gusset

Location Loc Qty Loc Code

Mezz2

7

116441

2

133228

5

100

Each

5.0000

1

3

133727 MF 15-7-13

PB67-43001-254

Manufactured

No

PR67-43001-254

Gusset

Location Loc Qty Loc Code

Mezz2

5

133227

5

133728 MF 15-7-13

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Picklist Print

Tuesday, June 16, 2015 10:54:52 AM

Page 2

Work Order ID: 133725

133725

Parent Item: PB67-43001-17

PB67-43001-17

Parent Item Name: Aft Adjustable Blade Support Assembly

Start Date: 6/16/2015

Required Date: 6/16/2015

Start Qty: 3.00

Required Qty: 3.00

PB67-43001-259

Manufactured No

100

Each

0.0000

1

3

PB67-43001-259

Inner Tube

MS124780

Purchased No

180

Each

77.0000

1

3

MS124780

HELICAL INSERT

**

133733 MF 15-7-13

**

Location

Loc Qty

Loc Code

ST260a

60

m128173

60

ST317

17

111064

17

MS27039-1-10

Purchased No

180

Each

362.0000

8

24

MS27039-1-10

SCREW

**

15/08/14 DAS 36 9-89

Location

Loc Qty

Loc Code

CA

41

m128635

41

GA

239

m129541

239

ST285

82

m123522

2

m130358

70

m130388

10

NAS1149D0316J

Purchased No

180

Each

345.0000

8

24

NAS1149D0316J

Washer

**

15/08/14 DAS 36 9-89

Location

Loc Qty

Loc Code

GA

132

122151

132

ST270

213

M127956

213

M132677 24X

Tuesday, June 16, 2015 10:54:52 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
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Picklist Print

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Page 3

Work Order ID: 133725

133725

Parent Item: PB67-43001-17

PB67-43001-17

Parent Item Name: Aft Adjustable Blade Support Assembly

Start Date: 6/16/2015

Required Date: 6/16/2015

Start Qty: 3.00

Required Qty: 3.00

NAS1149D0363J

Purchased

No

180

Each

1,765.000

8

24

NAS1149D0363.J

Washer

15/08/14

DAS
36
9-89

Location

Loc Qty

Loc Code

CA	569
m130799	569
GA	182
m128429	182
ST269	1014
m126319	7
m131618	7
m132317	1000

M132677
(2fx)

PB67-43001-73

Manufactured

No

180

Each

12.0000

1

3

PB67-43001-73

20 Degree Cover Plate

Location

Loc Qty

Loc Code

Mezz2	12
(111758)	11
90817	1

MF 15-7-13

PB67-43001-83

Manufactured

No

180

Each

24.0000

1

3

PB67-43001-83

D-Pad Assembly, Short

Location

Loc Qty

Loc Code

Mezz2	24
(111757)	24

MF 15-7-13

DQA: _____ Date: _____

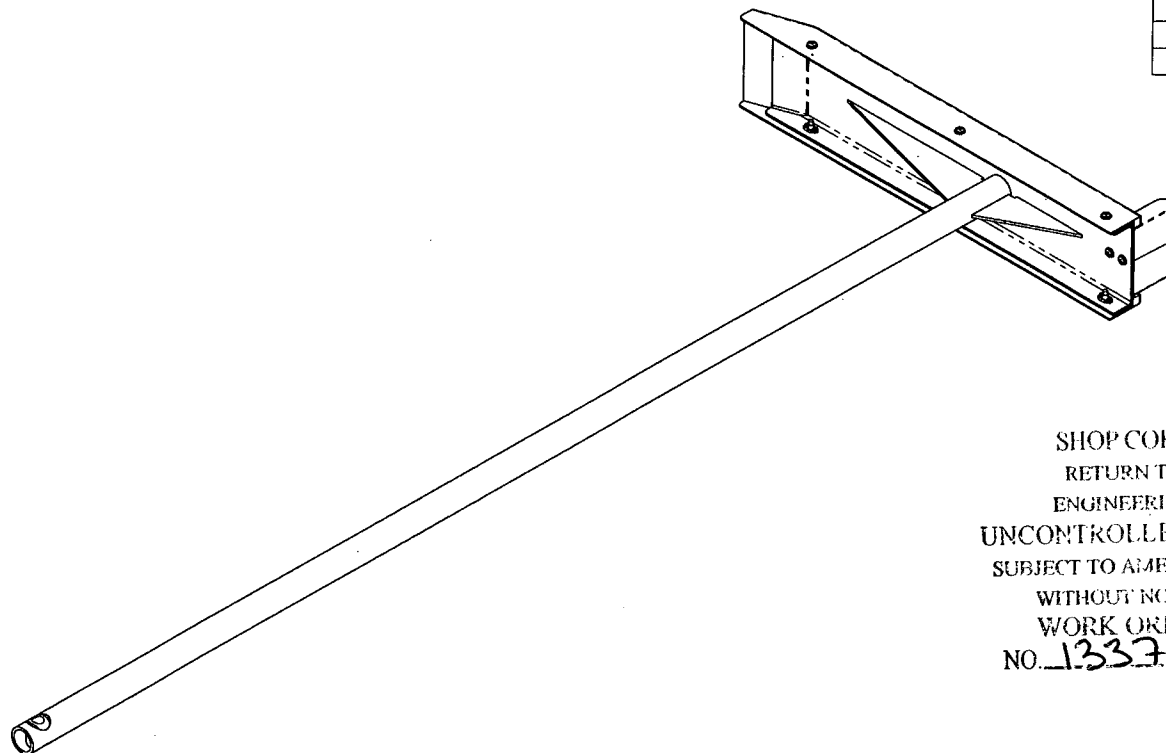


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
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OTHER : ☐					



B67-43001-17 AFT ADJUSTABLE BLADE SUPPORT ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 133725.MLS
15-06-17

ITEM	QTY -17	P/N	DESCRIPTION
1	X	B67-43001-17	AFT ADJUSTABLE BLADE SUPPORT ASSEMBLY
2	1	B67-43001-17W	AFT ADJUSTABLE BLADE SUPPORT WELDMENT
3	1	B67-43001-73	20" COVER PLATE
4	1	B67-43001-83	SHORT D-PAD ASSY
5	8	MS27039-1-10	SCREW
6	8	NAS1149D0316J	WASHER
7	6	NAS1149D0363J	WASHER

C		REDRAWN PREMIER AVIATION DRAWING IAW DART OSI 018 AND OSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 7 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	10.04.28
REV.	DESCRIPTION			BY	DATE
DESIGN	RW			DART AEROSPACE LTD	
DRAWN				HAWKESBURY, ONTARIO, CANADA	
CHECKED				DRAWING NO.	REV. C
MFG. APPR.				B67-43001-17	SHEET 1 OF 2
APPROVED				TITLE	SCALE
DE APPR.	N/A			AFT ADJUSTABLE BLADE SUPPORT ASSY	NTS
DATE	10.04.28			COPYRIGHT © 1985 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

D

C

B

A

D

C

B

A

B67-43001-17W AFT ADJUSTABLE
BLADE SUPPORT WELDMENT
REF

NAS1149D0363J
WASHER

MS27039-1-10 SCREW [8]
NAS1149JD0316J WASHER

B67-43001-73
20° COVER PLATE
REF

B67-43001-73
20° COVER PLATE

B67-43001-17W AFT ADJUSTABLE
BLADE SUPPORT WELDMENT

B67-43001-83
D-PAD ASSEMBLY, SHORT

SECTION A-A B7-2
SCALE 4X, 6 PL

B67-43001-17 AFT ADJUSTABLE BLADE SUPPORT ASSY

MS27039-1-10 SCREW
NAS1149JD0316J WASHER
2 PL [8]

C5-2

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.09 lbs
- 8) LOCATE PARTS AS SHOWN AND TRANSFER DRILL $\phi 0.250$ TO $\phi 0.257$ HOLES FROM EXISTING HOLE PATTERNS ON B67-43001-17W AND B67-43001-83 TO B67-43001-73

RELEASED
2010-08-16
MP

DESIGN	RW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		B67-43001-17	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.	N/A	AFT ADJUSTABLE BLADE SUPPORT ASSY	NTS
DATE	10.04.28	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8 7 6 5 4 3 2 1